

Wednesday, September 02, 2015 3:05:42 PM

Item ID: D5124-1

Revision ID:

Item Name: Fwd Support

Start Date: 9/1/2015 **Start Qty:** 8,000

Required Date: 9/1/2015 **Req'd Qty:** ~~8~~ 00

Reference:

Approvals: Process Plan: MUJ Date: SEP 03 2015 Tooling: Date:

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5124	B								

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FB340

Folio Rev: **AA**

Dwg Rev: 3

Deburr

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS					
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval			
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
☐ OTHER : _____									

Work Order ID 136362

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136362

Page 2

Item ID: D5124-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Support
Start Date: 9/1/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS
120									08
QC	Memo	0.00							9-89
Quality Control									

130	Identify as per dwg & Stock Location: LG54	0.00							DAS
130									41
Packaging	Memo	0.00							9-89
Packaging	LOCATION: LG55								15-11-9

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS

NOV 10 2015

MCS

NOV 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																							

Picklist Print

Wednesday, September 02, 2015 3:05:46 PM

Page 1

Work Order ID: 136362

136362

Parent Item: D5124-1

D5124-1

Parent Item Name: Fwd Support

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A RQ verified by JLM 14/08/08

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5124-1TRN / *D5124-1TRN* Support		Manufactured	No				Each	8.0000		8		DAS 20 9-89	15-11-02
									**	8 3.0			

Location

Loc Qty

Loc Code

MAT060

8

(135418)

8

(136456)

~~8~~ 2

~~8~~ 1

DQA: _____ Date: _____

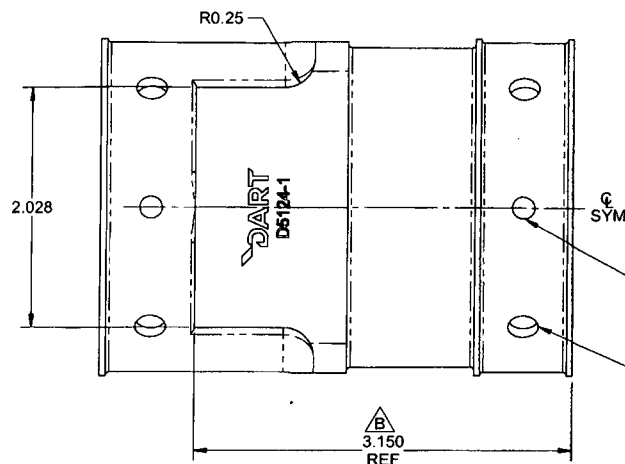


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

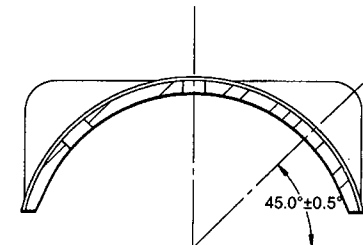
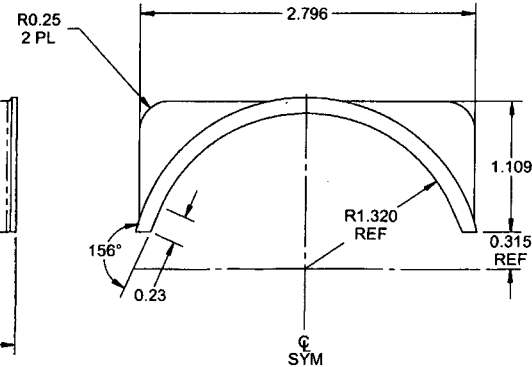
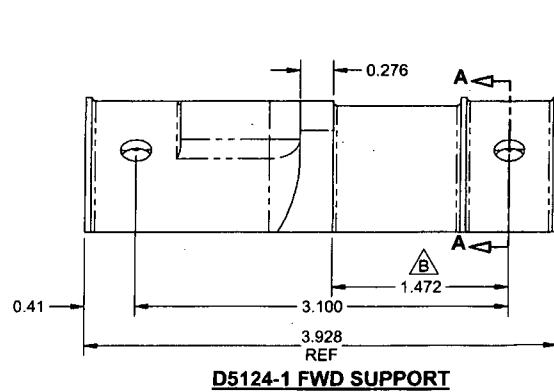
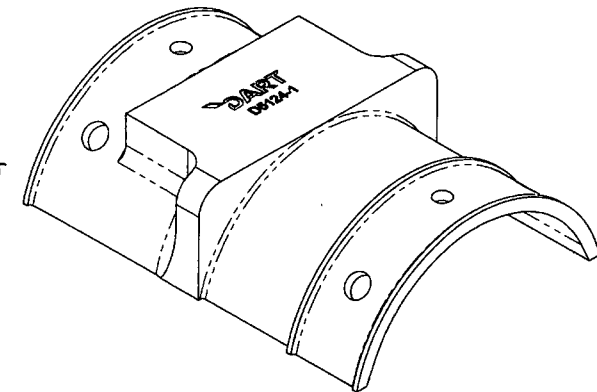
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Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER :																																																																							



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136362
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Ø0.188 TOOLING HOLE
SEE SECTION A-A
2 PL

Ø0.257 TOOLING HOLE
SEE SECTION A-A
4 PL



SECTION A-A RELEASED

2014 NOV 18

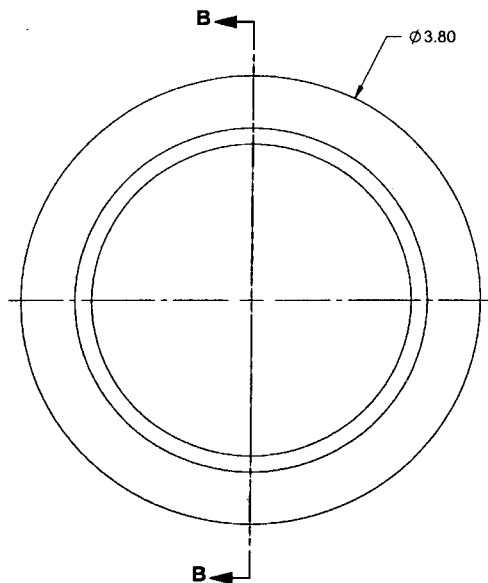
NOTES:

- 1) MATERIAL: MAKE FROM D5124-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5124-1" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1

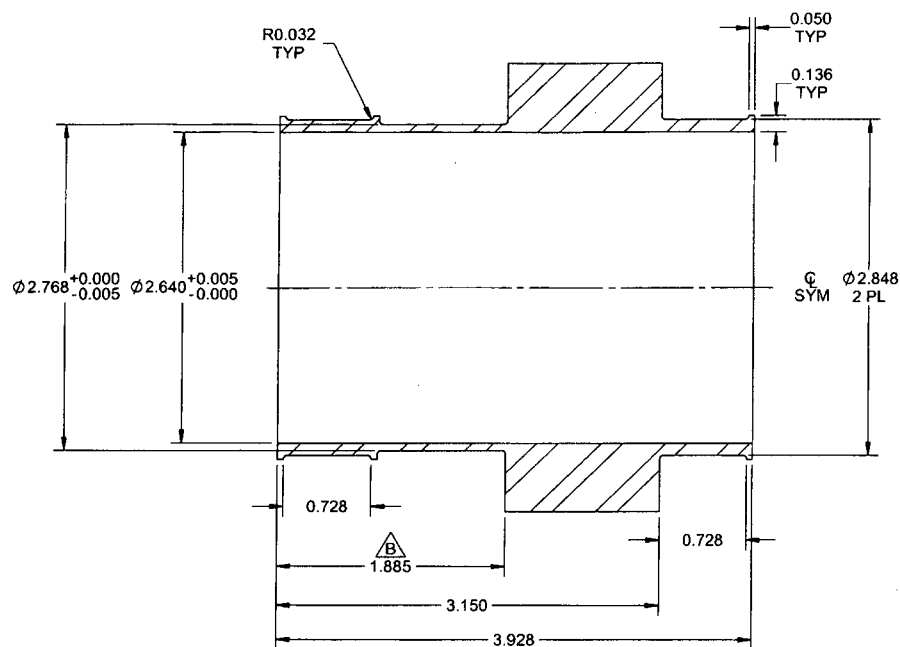
- 7) WEIGHT: 0.53 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5124-1-REV.B.SLDPR" "

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	RQ	D5124	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	FWD SUPPORT	NTS
DATE	14.10.28	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COPIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



D5124-1TRN FWD SUPPORT



SECTION B-B

RELEASED

2014 NOV 18

NOTES:

- 1) MATERIAL: 17-4PH/S17400/TYP 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R H900 OR H925 CONDITION, MIN UTS = 170 KSI (38HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.74 lbs

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	RO	D5124	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
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